	er ID 68905 5, 2011 10:52:13 AM									•	Page 1
Item ID: Revision ID:	D3414-041		Accept					Setup S	Start		
Item Name:	Lug Assembly	•						5	Stop		
Start Date: Required Date: Reference:	=	ety: 8.00 Qty: 8.00		Cust Item I Customer:	D:						
Approvals:	Process Plan:QC:	Date: 1-042	Tooling: SPC (Y/N):		ate:		I		Start Stop	-	
Sequence ID/ Work Center ID	Operatio Descript		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject umber	Insp. Stamp
Draw Nbr	Revision Nbr										
D3414	Rev C										
00 Waterjet		Memo	0.00				B11-5	5-4	_		
TOW CNC Waterjet		1-Cut as per Dwg D3414-1 Dwg Rev: Prog Rev:								(10)	
10	()C2- Insp.	2-Deburr if necessary ect parts off machine FAI/FAIB	0.00								
	QCZ- IIISP	Memo	0.00				PB11-	-5-4			

Quality Control

W/O:			W	ORK ORDER CHAN	IGES					*
DATE	STEP	PROC	EDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Cate	egory:	NCR	Yes N	o DQA:		Date:	
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NCR:		W	ORK ORD	ER NON-CONFORI	MANCE	(NCR)		•		
DATE	STEP	Description of NC Section A Corrective Action Initial Chief Eng Chief Erg			ection B	Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector
			Officer Eng	Criter Ling		Date				
•			ent :					-		

Work Order ID 68905

Monday, April 25, 2011 10:52:13 AM



Page 2

Item ID:

D3414-041

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

Required Date: 4/29/2011

Lug Assembly

4/25/2011

Start Oty: 8.00

Req'd Qty: 8.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

. Stop

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Run Hours 0.00

Total 6000

Tool ID

Tool # Plan Code Accept Qty Qty

Reject Reject

Insp. Number Stamp

130

Brake NC

Brake NC

Memo

1-Deburr

Memo

2-Form using DT8254 as per Dwg D3414

0.00

0.00

SB Maslas

.140

Large Fab Large Fab

0.00

0.00

1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M17659

Q 11-7-14

	•									•
W/O:			.WO	RK ORDER CHANG	ES				•	*
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DATE	STEP	Description of NC Corrective Action			on B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section	on C	Chief Eng	QC Inspector
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Work Order ID 68905

Monday, April 25, 2011 10:52:13 AM



Page 3

Item ID:

D3414-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 4/29/2011

Lug Assembly

Start Date:

4/25/2011

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

ADDIOVAIS.	Ap	prova	als:
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Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date: _____

SPC (Y/N):

Date:

Qty

Reject

Insp.

Sequence ID/ Work Center ID

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code Accept **Qty**

Reject Number Stamp

Memo

Memo

0.00

(pl 11.07.14 ______

160

QC5- Inspect part completeness to step on W/O



Quality Control

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: OVEN TEMPERATUR

FINISH TIME:

0.00

10 Bl 11-7-15.

170

Powdercoat Powder Coating

	Tospace	- Eta						·		·
W/O:			WO	RK ORDER CHAN	GES					·
DATE	STEP	PROC	EDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			ction B	0: 8		cation		Approval
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Work Order ID 68905

Monday, April 25, 2011 10:52:13 AM



Page 4

Item ID:

D3414-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Lug Assembly

Start Date:

Required Date: 4/29/2011

4/25/2011

Start Qty: 8.00

Req'd Qty: 8.00



Date: ______

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

QC:

Tooling: SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

180

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

Set Up/

Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Number

10 d 1 1105/15

Insp. Stamp

190



Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		,	WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Monday, April 25, 2011 10:52:19 AM

Work Order ID: 68905

Parent Item:

D3414-041

Parent Item Name: Lug Assembly



Start Date: 4/25/2011

Required Date: 4/29/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	153.6000	0.155	1.24	1B11-5-	-4	:
					113062 113077		Oty 153.6 121.6 32	Loc Code	1	(3067	_ <u>_</u>	(161)	
D3414-3		Manufactured	No	•		140	Each	17.0000	1 	8 <i>E</i> Z		14.	

Lug

Location Loc Qty Loc Code WA030 17 17

69887 X 8 70417 X 7

W/O:	•		W	ORK ORDER CHANG	ES				
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DATE	STEP	Description of NC			on B Sign &		cation	Approval	Approval
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								·	

DART AEROSPACE LTD	Work Order:	48905
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

	,				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject Method	
Ø0.313	+0.006/-0.001	313	×	VBOZ	
1.19	+/-0.030	1.184	4	ν	
1.00	+/-0.030	1.005	>	V	
3.38	+/-0.030	3.378	*	V	
5.350	+/-0.010	5.350	>	V	
6.23	+/-0.030	6.233	*	V	-
2.500	+/-0.010	2.495	*	V	•
0.37	+/-0.030	371	8	V	
0.100	+/-0.010	106	Þ	1	
					1. 40

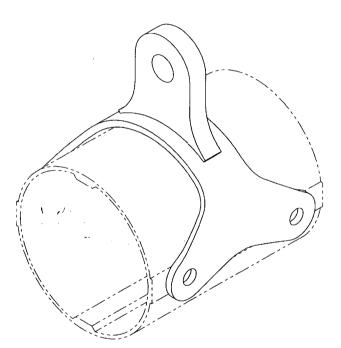
Measured by:	B	Audited by:	7	Prototype Approval:	N/A
Date:	11-8-4	Date:	11105/05	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
	В	09.05.27	Dimensions updated per Dwg Rev B	KJ 10	
i	C	09.10.16	Dwg Rev updated to Rev C	KJ X	W
		···	<u> </u>	/X/	

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION				
1 X		D3414-041	LUG ASSEMBLY				
2	1	D3414-1	LUG BRACKET				
3	1	D3414-3	LUG				



D3414-041 LUG ASSEMBLY

D

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs

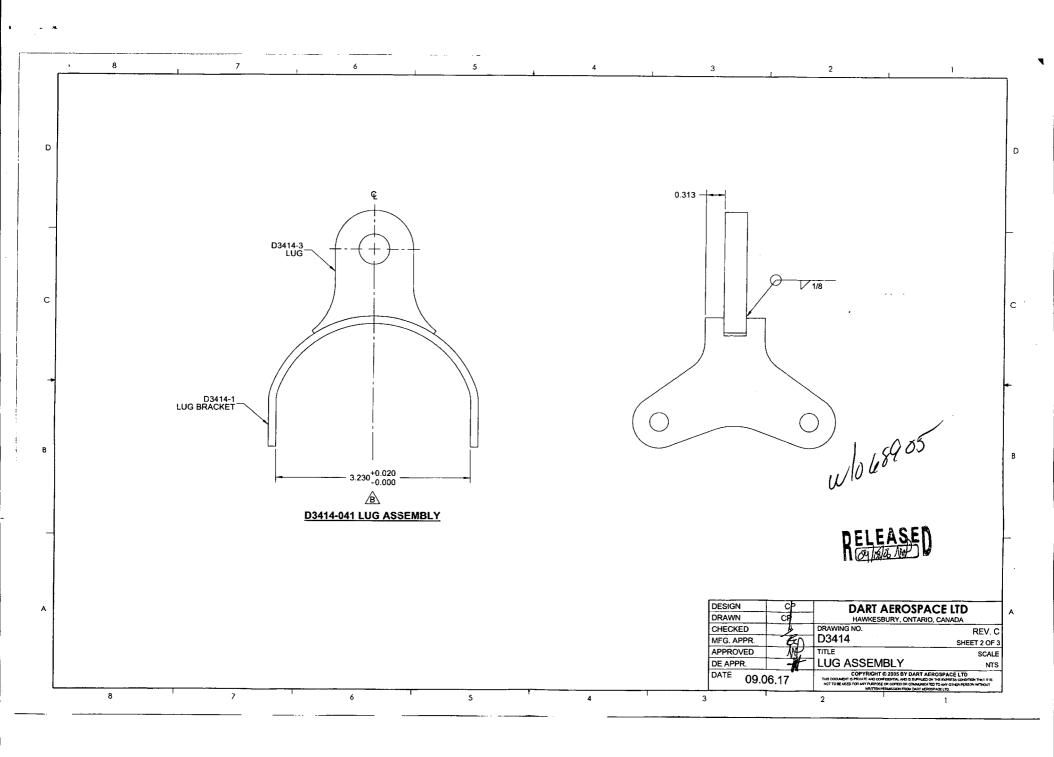
SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

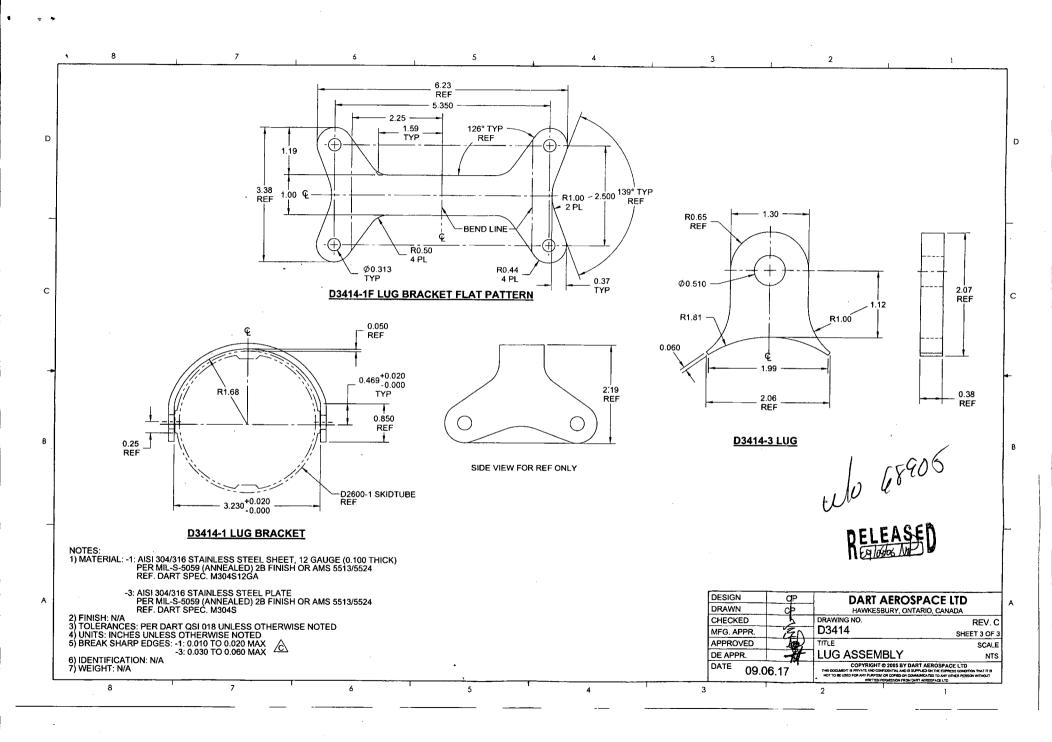
WORK ORDER NO. 48 905 21 11-04-25

С		SHARP EDGE: 030 (ZN A7-3)	СР	09.06.17				
В	STANDA FLAT PA PREVE REMOV OF MAN	NG REDRAWN ARDS AND TRA ATTERN FOR - NT FOULING A /ED FROM -1 (F NUFACTURE, B -3 1.12 DIM WA	AJS	08.09.23				
Α	NEW IS	SUE	CP	05.03.16				
REV.			BY	DATE				
DESIGN CIP			DART AEROSPACE LTD					
DRAWN CP		GP	HAWKESBURY, ONTARI					
CHECKED			DRAWING NO. REV					
MFG. APPR.		E	7 D3414	SHEET 1				
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DE APPR.		- A	LUG ASSEMBLY	ASSEMBLY NTS				
DATE 09.06.17			COPYRIGHT © 2005 BY DART A THIS COCUMENT IS PROVIDE AND CONFEDITING, AND IS SUPPLIED HOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNIC.	PLED ON THE EXPRESS CONDITION THAT IT IS				

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